NCR: Y	es /	No
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										DQA:	Date:	<u></u>
NCR: Y	es / No				WORK ORDER NON-	CON	IFORM	MANCE / UPI	DATE			
										QA Closed:	Date:	
Work Orde	rř.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde					Rework	ŋ [Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	о.				Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•				Use-as-is	1		noforming	Finishing	-	e/Packaging	Other
NCR N	lo				Work Order Update]						
Root				Descri	ption of work order update	ii	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator	_	l										
Material	_									1		
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Other						1						
Process	_			,								
Supplier	_								•			
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Unapproved		<u> </u>	<u> </u>				T CATE	CODY	<u> </u>			
1						AUL	T CATE	GURY				
Landir	Bending				General Bend		Grain		Г	Ovalized		Pressure/Forced
ŀ	Centre N	ot Conco	ntric to	~/s	BOM/Route	\vdash	Hardwa	are	-	Over/Under	tolerance	Temperature/Cure
}	Cracks	or conce	iitiic to	^{5/3} ⊢	Broken/Damaged	-		ion Incomplete	-	Part Incorred		Weld
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ŀ	Cuffs	Chapeu		-	Contamination	\vdash		enance	-	Part Moved		- 0
<u> </u>	Heat Trea	at			Countersink	1	Mislabe			Positioned V	Vrong _√	ŀ
	Inspectio		Tube		Cut Too Short	\mathbf{H}	Misread		<u> </u>	Power Loss/	- ' —	Other
	Ripples in				Drill Holes	Н	Offset		L			
ľ	Torque V		Extrusio	n	Drawing	\vdash		Calibration				
†	Turning S				Finish	П	Out of s	Sequence				
	Wave/Tw	vist in Tul	be		Folio	П	Outside	Dimensions	·	_,		

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Quality Control

Memo

QC

V	Jork	Orde	r ID	101	1037
•		171 U.			100/

Page 2

April-30-13 2:38:47 PM D3213-041 Accept *N900040100* Setup Start Item ID: **Revision ID:** Item Name: Door Assembly **Start Date:** 5/06/13 Start Qty: 4.00 **Cust Item ID:** Required Date: 5/06/13 **Req'd Qty:** 4.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Date: Approvals: Stop QC: Date: SPC (Y/N): Date: Tool ID Sequence ID/ Operation Set Up/ Tool # Plan Accept Reject Reject Insp. Qty Stamp **Work Center ID** Description Code Qty Number **Run Hours** 0.00 130 QC3- Inspect Part Finish Il 1210 € 18 *130* 0.00 OC Memo Quality Control 140 0.00 Small Fab *140* Small Fab 0.00 Memo Assemble as per Dwg D3213 Small Fab DAS QC5- Inspect part completeness to step on W/O 0.00 150

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-O	100	NFOR	MANCE / UPD	ATE	QA Closed:	Date:	
				u.	1						.=-	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,	PROCESS	
Part N	• , ,				Rework Skid-tube Scrap Machining Use-as-is Thermoforming				Crosstube Small Fab Finishing	l	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.					Ⅰ				Composite		Supplier	
Root				Descri	ption of work order update	Π	Initial	Actio	on	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descrip	otion	Date	Verification	QC Inspector
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Operator												
Material		ļ										
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Other												
Process												
Supplier		Į										
Training												
Unapproved		<u> </u>	<u> </u>			L						
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Landi	ng Gear				General		,			,		1
	Bending				Bend	\perp	Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	L	Inspect	ion Incomplete	<u> </u>	Part Incorred		Weld
	Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			L	Contamination	L	Mainte	enance		Part Moved		
	Heat Trea	at			Countersink	1	Mislabe	eled		Positioned W	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

Quality Control

101037

Page 3

April-30-13 2:3	38:47 PM									· ·		
Item ID: Revision ID:	D3213-041			Accept	*N900	040	100)* 5	Setup	Start	*N	S1*
Item Name:	Door Assemb	oly			· ·				•	Stop	*N	S2*
Start Date:	5/06/13	Start Qty: 4.00	*4*		Cust Item I	D:						
Required Date	: 5/06/13	Req'd Qty: 4.00	*4*		Customer:							
Reference:			•					_	_	0 4 4		•
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ite:		ŀ	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & Sto	ock Location 5	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
160 Packaging		Memo	, ,	0.00				-YX	<u></u>			* ` 6``
Packaging											12	-7J
170		QC21- Final Inspection -	Work Order Release	0.00						1		
470		2021 I mai inspection						ſ	Λ.	1 11	112-1	19-23

0.00

Memo

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NCR: \	res /	No

DQA: ____ Date: ___

NCR: Y	es / No				WORK ORDER NON-	CONFO	KIVIANCE / UI	PDATE	QA Closed:	Date	: :
Work Orde	ri:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update	rmoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other	
Root				Descri	ption of work order update	Initial	Α	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data									,		
quip/Tooling	_							•			
Operator	_								·		
Material	_										•
Setup				,							
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						AULT CA	regory		<u> </u>		···-
Landir	ng Gear			 	General			<u> </u>	1	F	-
	Bending			_	Bend	Grain		_	Ovalized		Pressure/Forced
1	Centre No	ot Concei	ntric to (o/s	BOM/Route	Hard		<u> </u>	Over/Under	<u> </u>	Temperature/Cure
	Cracks			ļ	Broken/Damaged	, 	ction Incomplete	· <u> </u>	Part Incorre	 	Weld
ļ	Crushed/	Crimped		_	Burrs	\vdash	uctions Incomplete	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs	Cuffs Contamination					ntenance		Part Moved		
	Heat Treat Countersink					Misla	beled	·	Positioned V		_
·	Inspectio		Tube	<u> </u>	Cut Too Short	Misre			Power Loss/	Surge	Other
	Ripples in Bend Drill Holes					Offset					
	Torque Waves in Extrusion Drawing					Out of Calibration					
ļ	Turning Sequence Finish						Out of Sequence				
	Wave/Tw	ist in Tub	oe .		Folio	Outs	de Dimensions				

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Picklist Print

April-30-13 2:38:46 PM

Work Order ID:

101037

Parent Item:

D3213-041

Parent Item Name:

Door Assembly

Start Date: 5/06/13

Required Date: 5/06/13

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Statu Issued
D2137		Manufactured	No			140	Each	27.0000	1	4	PA	2/29/
Decal - No Step											J) [3/0//
				<u>Location</u>		Loc Oty	<u>L</u> e	oc-Code				
				GA		27			 		\mathcal{B}	02952
		•			266	8						
					854	9			-	2		
2410			31.	99	733	10 140	Each	13.0000	<i>6</i>	-	11	
2419 Iandle		Manufactured	No			140	Each	13.0000		4	5/(13	109/19
iandie						1 0	-	C I .			7	
				Location		Loc Oty	L	oc Code			RI	12511
		•		GA	000	13			-		170	237/
					832 389	5 2			•			
					703	. 2						
02462		Manufactured	No			140	f	499.8338	2.4	9.6	01	
eal		Manufactured							#1500 WILL TO A STATE OF THE ST	· · · · ·	ذ السيك	109/17
				<u>Location</u>		Loc Qty	. 14	oc Code				
				ST403		499.8338	-				•	
					530	13.7336			-	·		
					ھــ 802	486.1002	*		<u> </u>	6	0	_ / /
03161-3		Manufactured	No			100	Each	5.0000	2	8	$\mathcal{I}\Lambda$	10/
linge 15.0"									Ø1	····	4	3/09/16
				Location		Loc Qty	L	oc Code			//	
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					776	4					· · ·	-
		1000		ST031		. 1					0	_
			**		310	1					B	98333

Page 1

NCR: \	⁄es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPE	DATE	QA Closed:	Date:		
Work Orde	er:					DISPOSITION			-	AGAINST DE		·		
Part N	٠ . ١٥٠					Rework Skid-tube Crosstu Scrap Machining Small F Use-as-is Thermoforming Finishi Work Order Update Large Fab Compos					Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other			
Root					Descri	ption of work order update		Initial	Acti	ion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descr	iption	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													·	
					1000	F	AUL	T CATE	GORY					
Landi	ng G	Gear			_	General	_	-		r	-		•	
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration		Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
		Turning S	equence		[Finish		Out of 9	Sequence					

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

'April-30-13 2:38:46 PM

Work Order ID:	101037 D3213-041						Start Dat	e: 5/06/13	Required Date: 5/06/13
Parent Item:							Start Qt		Reguired Qty: 4.00
Parent Item Name:	Door Assembly							y. 4.00	Keganed Qty. 4.00
D3213-1 Door Panel		Manufactured	No		100 Eac	ch	5.0000		45/3/09/16
				Location	Loc Qty		Loc Code	(4 <i>P)</i>	299796
				ST232	5		B96445		9 10 2000
				94288	5				- 0107165
D3213-3 Door Panel	•	Manufactured	No		100 Eac	ch	8.0000	1	4 2/3/09/18
				Location	Loc Oty		Loc Code	$\widehat{2}$	
				ST232	8		B98288C	,	_ / 570000
				68907	2		Diri		- 32000C
				74539	6				
MS20470AD4-4 Rivet, Universal Head	<i>,</i>	Purchased	No		140 Ea	ıch	6,368.0000	24	96 \$3/09/1
				Location	Loc Oty		Loc Code		
,				GA	1				_//
				121652	1		•		-80
				ST336	391				- M12500
				116188	68				- 1 (9/2)
				118614	135				_ (76)
				122027	188				_
				ST506	5976		•		_
				125268	5976	1	1.562.0000		<i>Q1</i>
MS20470AD4-6 Rivet, Universal Head		Purchased	No		100 Ea	icn	1,562.0000	CONTRACTOR OF THE PARTY OF THE	4 2/3/08/17
				Location	Loc Qty		Loc Code		
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				124231	1028				- /// · //
	*			ST505	515				_ (4)
				123021	515				

NCR:	Yes	1	Nο

, Date: ______

DQA:

NCR: Y	es / No				WORK ORDER NON-O	CONF	ORN	//ANCE / UP	DATE				
										QA Closed:	Date	e:	
Work Orde	r:				DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	:	
Part N					Rework Scrap	7 1 1	ľ	Skid-tube Machining	Crosstube Small Fab	Pro	Engineering Quality		
. · NCR N	0	,	······································		Use-as-is Work Order Update	<u> </u>		noforming Large Fab	Finishing Composite	Rec/Store/Packaging Other Supplier			
Root				Descri	ption of work order update	Init	ial	Act	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data]					I					
quip/Tooling								ļ					
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Landin	- Coor				F General	AULT (CATE	JORT					
	Bending			Г	Bend	Пе	rain			Ovalized	Г	Pressure/Forced	
-	Centre No	ot Conce	ntric to		BOM/Route		ardwa	ro	-	Over/Under	tolerance	Temperature/Cure	
<u> </u>	Cracks	ot conce	incinc to	°′° -	Broken/Damaged	\vdash		on incomplete		Part Incorred		Weld	
-	Crushed/	Crimned			Burrs	├ ──	-	ions Incomplete/l	Unclear —	Part Lost/Mi	-	Wrong Stock Pulled	
	Cuffs	Cimped		F	Contamination			nance	-	Part Moved			
-	Heat Trea	at .		ļ	Countersink	\blacksquare	islabe			Positioned V	/rong		
<u> </u>	-		Tube		Cut Too Short		isread		<u> </u>	Power Loss/		Other	
<u> </u>	Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes					\vdash	ffset			」	<u> </u>		
ŀ	Torque Waves in Extrusion Drawing					Out of Calibration							
ľ	Turning S				Finish	\vdash		Sequence					
Ī	Wave/Tw				Folio	\vdash		Dimensions					

Picklist Print

April-30-13 2:38:47 PM

Page 3

Work Order ID:

101037

Parent Item:

D3213-041

Parent Item Name:

Door Assembly

NAS1149DN632J

Washer

Purchased

No

Start Date: 5/06/13

66.0000

Start Qty: 4.00

Required Qty: 4.00

Required Date: 5/06/13

Loc Code Location Loc Qty 66 ST293 66 123900

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Each

			,							DQA:	Da	ite: _	
NCR:	es / No				WORK ORDER NON-	COI	NFORI	MANCE / UPDATE		·			
										QA Closed:	Da	ite:	
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N				····	Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Water Je Prod. Eng. Coor Rec/Store/Packaging			Engineering Quality Other
NCR N	No				Work Order Update	1	rriciti	Large Fab Composite	_]	Supplier	-	
Root				Descri	ption of work order update		Initial	Action		Sign &		ĺ	
Cause	Date	Step	Qty	,	or Non-conformance	Ct	nief Eng	Description		Date	Verificatio	n	QC Inspector
Doc/Data													
Equip/Tooling		1											
Operator													
Material													
Setup				[
Other													
Process												•	
Supplier													
Training				ļ								l	
Unapproved		<u> </u>	<u>l</u>	<u> </u>		<u> </u>						l	
						AUI	T CATE	GORY			·		
Landi	ng Gear			_	General	_	1		_	1			_
	Bending				Bend		Grain			Ovalized			Pressure/Forced
	Centre Not Concentric to O/S				BOM/Route	Hardware			<u> </u>	Over/Under		\vdash	Temperature/Cure
	Cracks				Broken/Damaged	⊢		on Incomplete		Part Incorred		ы	Weld
	Crushed/Crimped				Burrs		Instructions Incomplete/Unclear		Part Lost/Mis	ssing	Ш	Wrong Stock Pulled	
	Cuffs				Contamination	\vdash	Maintenance			Part Moved			
ł	Heat Treat				Countersink		Mislabeled			Positioned W	/rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

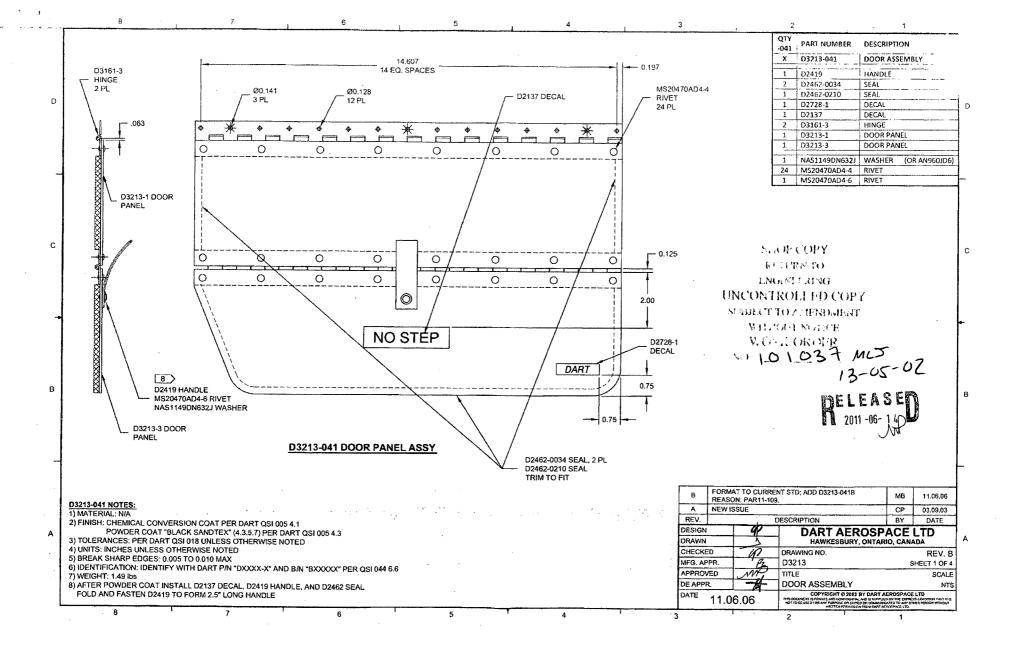
Cut Too Short

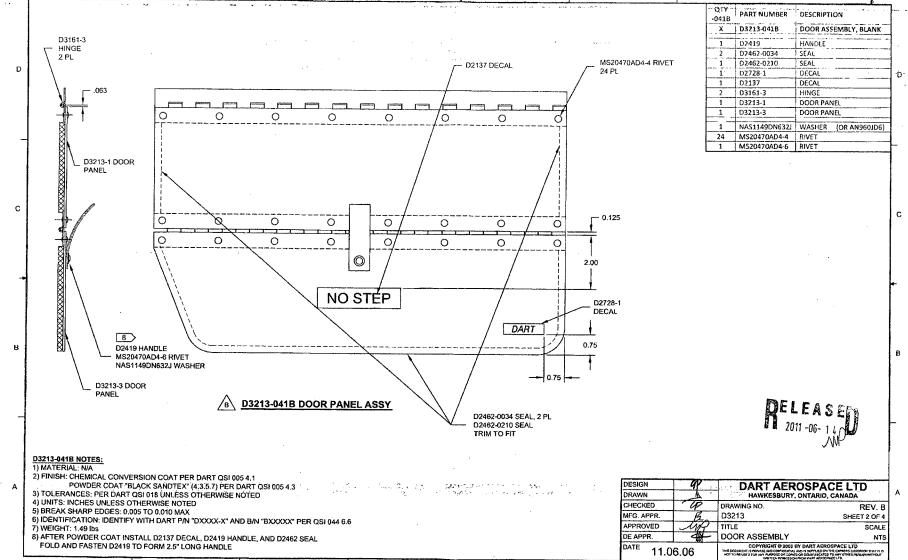
Drill Holes

Drawing

Finish

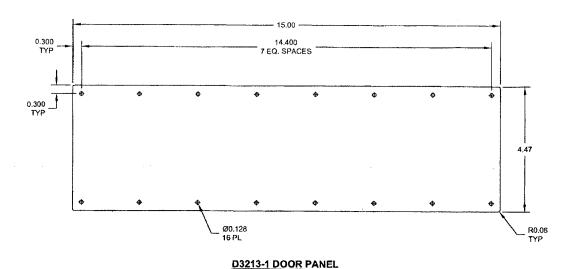
Folio





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С



D

D3213-1 NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063

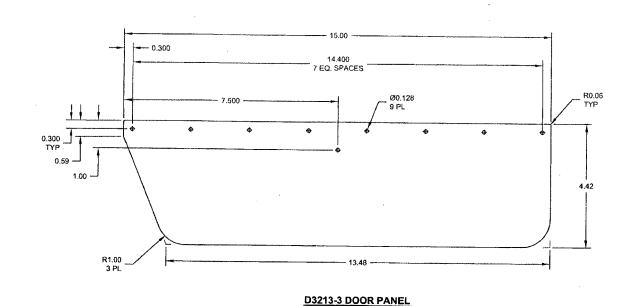
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.42 ibs

6

DESIGN DRAWN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED	a	DRAWING NO.	REV. B		
MFG. APPR.	B	D3213	SHEET 3 OF 4		
APPROVED	Just	TITLE	SCALE		
DE APPR.		DOOR ASSEMBLY	NT		
DATE 11.0	06.06	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS REMAIT, AND COMPREMIAL AND IS SUMFLED ON THE EXPLAISE COMMITTED THAT IT IS HIGHTORS USED ON ANY TOPPOSE OR COMPLETO AND COMPLETACION OF THE PROSECULATION OF THE PR			

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D3213-3 NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.39 ibs

DESIGN	97	DART AEROSPACE L					
DRAWN	b)	HAWKESBURY, ONTA					
CHECKED	W	DRAWING NO.	REV. B				
MFG. APPR.	B	D3213	SHEET 4 OF 4				
APPROVED	JIND	TITLE	SCALE				
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DATE 11.0	06.06	TOPYRIGHT © 2003 BY DART AEROSPACE LTO THIS DOCUMENT SWEWLE AND CORPORATION HIS DOCUMENT OF THE SECOND HIS TOP THE SECOND HIS T					